

Date: Wednesday, 8/30/2006 11:57:24 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GASKET
 Job Number : 28360
 Estimate Number : 12510
 P.O. Number : N/A Part Number : D35221
 This Issue : 8/30/2006 S.O. No. : N/A Drawing Number : UNDER REVIEW CB 06.09.30
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : N/A
 Previous Run : N/A Material : N/A
 Written By : Due Date : 9/6/2006 Qty: 1 Um: Each
 Checked & Approved By : 06.08.30
 Comment : Est Rev:A New Issue 06-08-21 JLM

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MNEO50S031 NEOPRENE SHEET 0.031



Comment: Qty.: 0.0368 sf(s)/Unit Total : 0.0368 sf(s)

0061 T6 .040 Sheet

(M6061T6S040)

Batch:

Neoprene sheet - 0.031" thick 60 Diameter
 B20359
 D3195 batch: 16.11.19

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3514

Dwg Rev: Rev 1

Prog Rev: Rev 1

Ensure Grain Direction is correct** N/A

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form Joggle as per Dwg D3514

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 8/30/2006 11:57:24 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 28360

Part Number: D35221

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EC 06.09.19

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

not required

CB

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

07/03/09

Job Completion



U 07.03.09

*Engineering Approval
Project Manager*

*CB
07.03.08*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

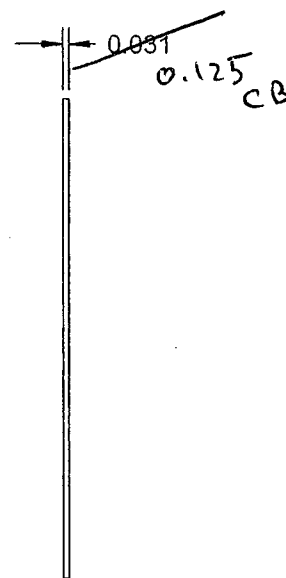
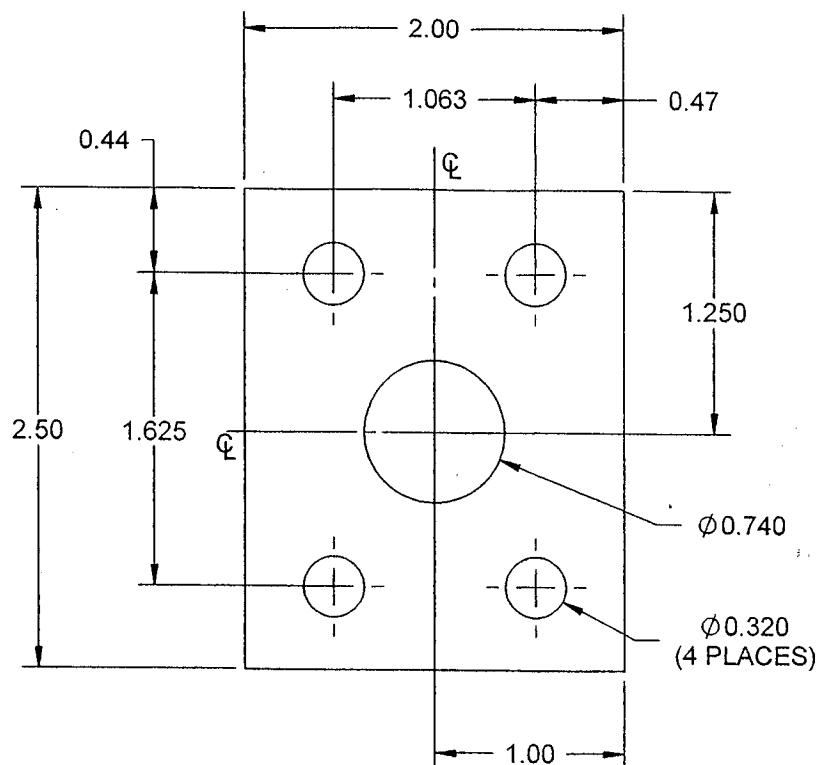
PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3522	REV. A SHEET 1 OF 1
DATE 06.05.08	TITLE GASKET SCALE 1:1		
A	06.05.08	NEW ISSUE	

UNDER REVIEW

06.08.22 CB

prototype



D3522-1 GASKET

NOTES:

- 1) MATERIAL: 1/32 (0.031) THICK NEOPRENE SHEET (REF. DART SPEC. M-NEO50-8.031)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT ϕ

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
28360

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



www.ACRrubber.com

12771 No. 5 Road
Richmond, B.C.
Canada V7A 4E9

Tel: 604-274-9955
Fax: 604-274-1013
Toll Free: 1-888-478-2237

PACKING SLIP

CUSTOMER COPY

PACKING SLIP

00111072

CUSTOMER NO.

10750

PST# OCP

S
O
L
D
T
O
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON L6A 1K7
CANADA

S
H
I
P
T
O
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON L6A 1K7
Canada

820350

DATE		SHIP VIA		TERMS	
2/10/04		A/R		NET 30 DAYS	
PURCHASE ORDER NUMBER		DATE ORDERED		SALES PERSON	
2006073		02/15/04		GARYS	
QUANTITY		ITEM NUMBER		DESCRIPTION	
ORDERED	SHIPPED	B.O.			
40	20		NEO60-02	NEO 60-1/8"	SF
				RS: 6'X100'	
				LBS/SQFT: .9675	
				END A LETTER OF COMPLIANCE WITH P/S	
				SUBTOTAL	
				GST	
				TOTAL AMOUNT	
FREIGHT: 10.00					

Rubber Products Engineered To Your Requirements
Specialists in Bonding Natural and Synthetic Rubber To Metal
Moulded and Extruded Rubber Products, Cast Polyurethane Specialties



12771 No. 5 Road
Richmond, B.C.
Canada V7A 4E9
Telephone (604) 274-9955
Fax (604) 274-1013

CERTIFICATE OF COMPLIANCE

Date : 02/16/2004

Customer : Dart Aerospace LTD

Customer P.O. # : 2006078

Specification: Neo 60-1/8"

Customer Ref.# / Stock # : _____

Serial # : _____

ACR W.O. # : 111072

Item # : NEO 60-02

Item Description: NEO 60-1/8"


ACR Compound: _____

Date Shipped: 2/16/04

Carrier: PUROLATOR AIR

B / L : _____

This Certifies that to the best of our knowledge the material delivered under this contract is in accordance with the terms of the contract, and with ACR Group quality standards.


(ACR GROUP INC. REPRESENTATIVE)

DART AEROSPACE LTD

Work Order: 20359

Description: Neoprene 1/8" thick

Part Number: D3195

Dwg: D3195 Rev. A page 1

Qty: 50

Ref:

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	04.02.12	50
2	PG	Issue P/O 2006078 Material: 60° Durometer Neoprene 1/8" thick Possible Supplier: Accurate Rubber, roll 12" x 50' length	U	04.02.12	50
3	RG	Receive and Inspect for transit damage	Q	04.02.17	50
4	QC6	Inspect dimensions 12" x 1/8" thick 48 RB	RB	04.03.22	50
5	ST	Identify and Stock	Q	04.03.22	50
6	AC	Cost / part 2.15 545	545	04.03.23	50
7	DC	Close W/O 2.14 Inspect Level 21	KJ	04.03.26	50

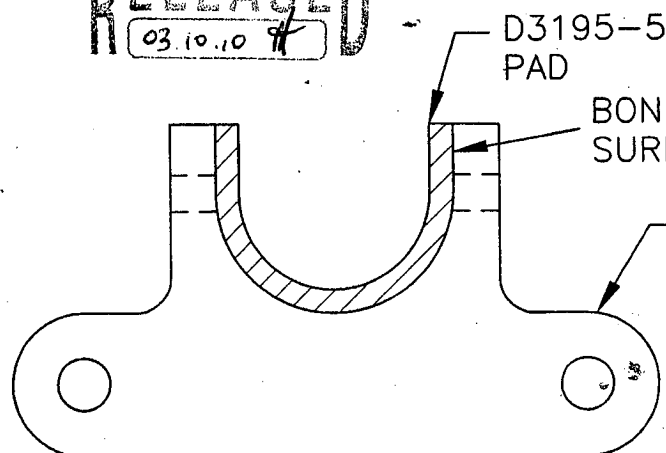
Rev	Date	Change	Revised By	Approved
A	03.10.17	New issue	KJ/RF	RF

RELEASED
04.01.12

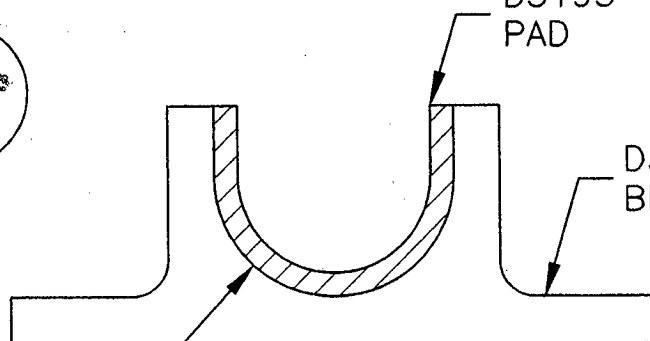


DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D3195	REV. A SHEET 1 OF 3
DATE	03.06.23			TITLE BRACKET	SCALE 1:1
A	03.06.23			NEW ISSUE	

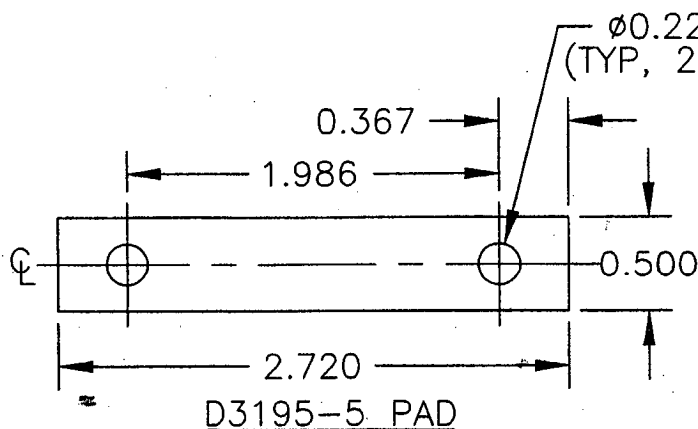
RELEASED
03.10.10



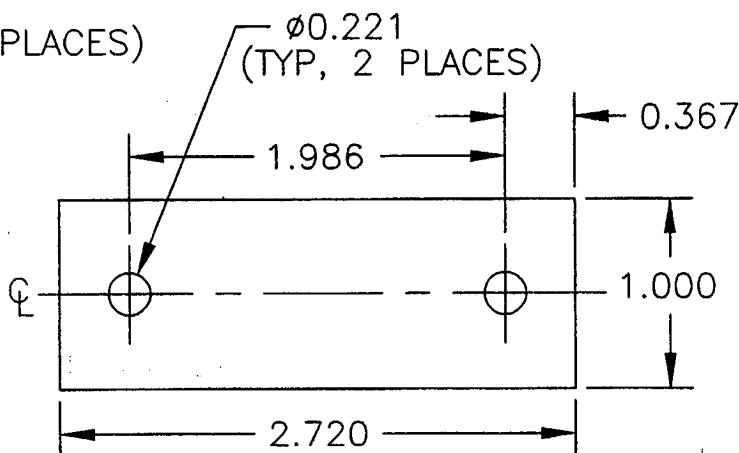
D3195-041
BRACKET



D3195-043
BRACKET



D3195-5 PAD



D3195-7 PAD

D3195-5 & D3195-7 PAD

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 20359
D3195-7
PAD

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 12, 2004
07:58 am

Work Order No	: 0020359	Department Code:	
Project Name	: D3195	Burden Flags	: NNNNNNNN
Project For	: WK407	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D3195	Invoice Number	:
Description	: Neoprene 1/8" thick	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 50	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 02-12-04		
Est Finish Date	: 02-20-04	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
=====					
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====					
Burden	: 0.00	0.00	0.00		
=====					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

Inc.

ACRrubber.com

12771 No. 5 Road
Richmond, B.C.
Canada V7A 4E9

Tel: 604-274-9955
Fax: 604-274-1013
Toll Free: 1-888-478-2237

PACKING SLIP

CUSTOMER COPY

PACKING SLIP

00111072

CUSTOMER NO.

10750

PST# OOP

S
O
L
D

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWTHORNSBURY, ON K6A 1K7
Canada

S
H
I
P

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

[illegible]

Rubber Products Engineered To Your Requirements
• Specialists in Bonding Natural and Synthetic Rubber To Metal
Moulded and Extruded Rubber Products, Cast Polyurethane Specialties



12771 No. 5 Road
Richmond, B.C.
Canada V7A 4E9
Telephone (604) 274-9955
Fax (604) 274-1013

CERTIFICATE OF COMPLIANCE

Date : 02/16/2004

Customer : Dart Aerospace LTD

Customer P.O. # : 2006078

Specification: Neo-60-1/8"

Customer Ref.# / Stock # : _____

Serial # : _____

ACR W.O. # : 111072

Item # : NEO 60-02

Item Description: NEO 60-1/8"

ACR Compound: _____

Date Shipped: 2/16/04

Carrier: PUROLATOR AIR

B / L : _____

*This Certifies that to the best of our knowledge the material delivered under this contract is in accordance with the terms of the contract, and with ACR Group quality standards.


(ACR GROUP INC. REPRESENTATIVE)